Item ID: D4 Revision ID:	12-704-011									
Item Name:CopStart Date:7/1	oilot Emergency Cargo Release 0/12 Start Qty > 00	Z *5*	Accept	*N900 Cust Item I		100)* 5	Setup Sta	1/1	S1* S2*
Required Date: 8/1 Reference:	0/12 Req'd Qty: \$00	*5*		Customer:						
Approvals: Pi	rocess Plan: MC 5	Date: 12/07/19 Date:	Tooling: SPC (Y/N):		nte:		I	Run Sta Sto	n 1/1	R1* R2*
Sequence ID/ Work Center !D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
IIN-D412-704	С									
*100 *100* DC Document Control	DOCUMENT CONTRO Memo Photocopy	DL bluefile and create labels pe	0.00 16 0.00 0.00 0.01 CF	(2/08/2)				Mc	5_12	108 29
*110 *110* Packaging Packaging	Pick Kit Memo		0.00				2			12/08/29 ED
120 *120* QC	QC4- 100% Inspect kits Memo	for completeness	0.00 A	Noelso			(+l)		

Quality Control

NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UPDATE		-		· ·
											QA Closed:	Date:	•
Work Ord	er.					DISPOSITION			AG	AINST DE	PARTMENT/	PROCESS	
Part I	 No					Rework Scrap Use-as-is Work Order Update		f Therm	Machining Sm noforming Fir	sstube all Fab nishing posite ,		Water Jet J. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause	į	Date	Step	Qty	c	or Non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								.≏ 3 ¢				•	
					······	 	AUL	T CATE	GORY				
Landi		ear Bending Centre No Cracks Crushed/C Cuffs Beat Treat	rimped.		D/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		1 '	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorred Part Lost/Mis Part Moved Positioned W Power Loss/S	t ssing /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	-	innles in	•			Drill Holes		Offcet		<u> </u>	•	<u> </u>	

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

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Work Ord <i>July-18-12 1:0</i> :		7367		Page 2					
Item ID: Revision ID: Item Name:	D412-704-0	011 rgency Cargo Release		Accept	*N90004	0100	* Set	up Start Stop	*NS1* *NS2*
Start Date: Required Date Reference:	7/10/12 : 8/10/12	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item ID: Customer:				
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):	Date:		Rui	n Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I 130 *120* Packaging Packaging	D	Operation Description Packaging Memo Identify and 011Location	pack for shipping as pe PPP R	Set Up/ Run Hours 0.00 0.00 r PPP D412-704- ev:	Tool ID Tool	Code	-		Reject Insp. Number Stamp
140 *140* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00		-	<i>/</i> -	nct	15/08/30

NCR:	Yes /	No			-	WORK ORDER NON-O	COI	NFORM	MANCE / UPI	DATE			7
									_		QA Closed:	Date	
Work Ord	er.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part I	Part No. NCR No. Root Des					Rework Scrap Use-as-is Work Order Update		ſ	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		T			Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause	ם	ate	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved										•			
	 						AUL	T CATE	GORY				
Landi	Cen Crad Crus Cuff Hea Insp	ending Entre Not Concentric to O/S Eacks Ushed/Crimped. Bend BOM/Route Broken/Damaged Burrs						i	on Incomplete ions Incomplete/U nance Ied	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Calibration

Outside Dimensions

Out of Sequence

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Page 1

Work Order ID:

87367

Parent Item:

D412-704-011

Parent Item Name:

Copilot Emergency Cargo Release

Start Date: 7/10/12

Required Date: 8/10/12

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:B05.01.28Hardware added to Step 3KJ/RF

IPP Rev:C05.12.21Hardware removed on Step 3 EC IPP REV:D AS PER REV C JLM

VERIFIED BY:EC

IPP REV:E 12.05.10 per ECN 12-583 DD verf:EC

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
	0412-704-041 Pedal Assembly (205/212/	214/412)	Manufactured	No			110	Each	3.0000	1787	884 5-2	2/	9	
a F					Location		Loc Oty	Lo	c Code			U		
	i				ST203		3							
					859	54	3			1 <u>X-8:</u>	5954			
Í	0412-704-045	(412)	Manufactured	No			110	Each	3.0000	Û	5 2	1 - 11	5	· (=0
KC"	्विable Assembly (212/214/	412)			Location		Loc Oty	Lo	c Code					ST.
					ST223		3							
1					864	59	3			8	6457			
	D3207-5		Manufactured	No			110	Each	19.0000	Ū	5 2	2 V gg	3	Re
	Bracket				Location		Loc Oty	Lo	c Code					0
					ST		10							
					859	99	10				<u>_</u>			
					ST202		9							
					702		1				CG94			
. 57	D3207-7		Manufactured	No	859	94	110	Each	10.0000		5 6	2 - 2,	B	E P
₹VI	Packer				<u>Location</u>		Loc Qty	Lo	c Code	· · · · · · · · · · · · · · · · · · ·			V	Dij#
	4				ST202		10							
					821	98	10			Ste	198			
¶ بر√د	D3207-11 Bracket		Manufactured	No			110	Each	4.0000		<i>5</i> 3	2 / 31	B 12	108/2
Α,					Location		Loc Oty	<u>L</u> c	c Code			•		,
					ST197		4				- - 11		~ V	
					852	11	4			8:	5211			

NCR:	\cdot											
										QA Closed:	Date	: ,
Work Orde	er:			•	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	Part No. S Use- NCR No. Work Order Upo						Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	1	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance,	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator						1						
Material												
Setup		l						٠				
Other		l										
Process												
Supplier	_											
Training												
Unapproved						<u>.i</u>				<u> </u>		
						AUL	T CATE	GORY				· · · · · · · · · · · · · · · · · · ·
Landir	ng Gear				General		1			7	_	¬
ļ	Bending				Bend	_	Grain			Ovalized		Pressure/Forced
ļ	Centre No	ot Concer	ntric to C)/S	BOM/Route	_	Hardwa			Over/Under	-	Temperature/Cure
	Cracks			_	Broken/Damaged		1 '	on Incomplete		Part Incorred	 	Weld
	Crushed/	Crimped.		ļ	Burrs	_	•	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			-	Contamination	\perp	Mainte			Part Moved		
ļ	Heat Trea				Countersink		Mislabe			Positioned V		- -1
	Inspection	-	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
Ripples in Bend Drill Holes						Offset						
	Torque W	aves in E	xtrusion		Drawing		Out of C	alibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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July-18-12 1:09:41 PM

Work Order ID:	87367	•							
Parent Item:	D412-704-011						Date: 7/10/12	Required Date:	
*Parent Item Name:	Copilot Emergency Cargo Release					Star	t Qty: 5.00	Required Qty:	5.00
D3208-1 Doubler	Manufactured	No		110	Each	11.0000		\$ 20 93	568
			Location	Loc Qty		Loc Code	•		•
			ST202	11				_	
			83920	11			83920		
D3208-11 Filler	Manufactured	No		110	Each	3.0000	1 8664	25 2 JB	_SP_
			Location	Loc Qty		Loc Code		·	·
			ST202	3					
1			82201	3					
D320823 Pedal Mount Angle	Manufactured	No		110	Each	14.0000	للتا	52/1B	[26]
			Location	Loc Oty		Loc Code		V	,
			ST202	14					
	u -		82587	2			1+8258	7	
i			85947	6			11 8594	7	
1			86002	6					
P3208 =7 Filler	Manufactured	No		110	Each	20.0000		5 J JB	- 80
			Location	Loc Qty		Loc Code		,	ر الق
1			ST202	20				(
			83918	20			8391	Z	
D3208-9 Doubler	Manufactured	No		110	Each	5.0000		52 V1B	A P
)			Location	Loc Oty		Loc Code			0,
			ST202	5					
			83940	5			8394	<u> </u>	
D3214-1	Manufactured	No		110	Each	11.0000	d	52 × 1B	12/08/
Placard								7	19/0-7
•			Location	Loc Qty		Loc Code		8	8
			ST202	11			8258		,
			82585	3			8 0 2 8	<u></u>	
			83919	 8					Page

NCR:	Yes	/ No				WORK ORDER NON	-CO	NFOR	MANCE / UPD	DATE			
									_	ē.::	QA Closed:	Date	:
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part	-					Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No					Work Order Update		!	Large Fab	Composite]	Supplier	
Root					Descri	otion of work order update		Initial	Acti	on	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	C	hief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							FAU	LT CATE	GORY				
Landi		Bending Centre No Cracks Crushed/C Cuffs Heat Trea Ripples in	Crimped. t n Strip in		D/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		⊣ `	on Incomplete ions Incomplete/U nance led	nclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	П	orque W	aves in E	xtrusion		Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

July-18-12 1:09:41 PM

Work Order ID:

87367

Parent Item:

D412-704-011

Parent Item Name:

Copilot Emergency Cargo Release

MS21919-DG5

Purchased

No

Start Date: 7/10/12

Required Date: 8/10/12

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Start Qty: 5.00

Required Qty: 5.00

208 JB 12/08/29

Location	Loc Qty		Loc Code	
306	17	•		
121652	17			121652
ST306	26			
119638	1			
120731	25			

Each

43.0000

110

Yes	/ No		,		WORK ORDER NON-	O	NFORM	MANCE / UP	DATE					,
											QA Closed:	D	ate:	
er.					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
Part No. NCR No. Root Des					Rework Scrap Use-as-is Work Order Update		Therm	Machining noforming	Small Fab Finishing		4			Engineering Quality Other
					•	1	1		-		Sign &			
_	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desci	ription		Date	Verificati	on	QC Inspector
					<u>F</u>	AUL	T CATE	GORY						· · · · · · · · · · · · · · · · · · ·
Bending Centre Not Concentric to O/S Cracks Broken/Damaged Crushed/Crimped Cuffs Cuffs Contamination Heat Treat Inspection Strip in Tube Bend BOM/Route Broken/Damaged Contamination Countersink Cut Too Short					Inspection Instruction Mainteo Mislabeo Misread	on Incomplete ions Incomplete/U nance led	Jnclear		Part Incorred Part Lost/Mi Part Moved Positioned V	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	er: No.	No	er: No. Date Step Date Step Bending Centre Not Concer Cracks Crushed/Crimped. Cuffs Heat Treat	er: No. Date Step Qty Date Step Qty Bending Centre Not Concentric to Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube	er: No. No. Date Step Qty Descri Date Step Oty Consequence of the process o	Process Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Disposition Rework Scrap Use-as-is Work Order Update Find the service of the s	Process of the proces	Process of the proces	Processing State Disposition Rework Scrap Work Order Update Large Fab Large Fab Date Step Qty Description of work order update Chief Eng Description Of work order update Description Of work order update Description Of work order upd	Principle of the property of t	Procession of the process of the pro	Part Category Part Part	Provided to the content of the conte	Pate Disposition Rework Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor. Recyfstore/Packaging Large Fab Composite Date Step Qty Description of work order update Chief Eng Description Date Verification Date Date Step Qty Or Non-conformance Chief Eng Description Date Verification Date Ve

Out of Calibration
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5.0 PARTS LIST

Sty-	Qty	Qty	Qty	Qty	Qty	Qty		
011-	-013	-015	-041	-141	-043	-045	Part Number	Description
Х							D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	Х						D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (205)
_,		х					D412-704-015	COPILOT'S EMERGENCY CARGO RELEASE KIT (412)
/1	1		Х				D412-704-041	-PEDAL ASSEMBLY (205/210/212/214)
		1		X		<u> </u>	D412-704-141	PEDAL ASSEMBLY (412)
-	1_				_X		_D205-704-043	CABLE ASSEMBLY (205)
/_1_		1_				X_	-D412-704-045	CABLE ASSEMBLY (210/212/214/412)
								
	-		1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
			1	1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
			1	1		T	D3205-3	BACK PLATE (OR ECM 999709-5)
$\neg \neg$			1	1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1				ĺ		D3207-1	BRACKET
	1						_D3207-3	BRACKET
71		1					D3207-5-	BRACKET
71	1	1					-D3207-7	PACKER
<u></u>	· · · · · ·	1					D3207-9	BRACKET
7 1							D3207-11 /_	BRACKET
1 1	1	1					D3208-1	DOUBLER (OR ECM 999709-1)
1		1					D3208-11 🔟	FILLER
71	1	1			<u> </u>		_D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
-	1	 					D3208-5	MOUNT ANGLE
71	1	1					D3208-7-	FILLER (OR ECM 999709-3)
<u></u>		-1-				-	D3208-9	DOUBLER
		 		1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
<i>(</i> 1	1	1					D3214-1	PLACARD (OR ECM 999712-1)
` '	<u> </u>	 '	*		1	***	D3217-1	CABLE
A					† •	1	D3217-3	CABLE
11		 	 		1	1 1	D3257-1	FITTING
11			<u> </u>	 	1	1	D3258-1	ANGLE BRACKET
11		1	 	-	 	<u> </u>	D4610-1	DOUBLER
-11-		 	1				D4610-3	DOUBLER
11	-	 	1	1	 	 	D4610-5	SHIM
3)		1	 	+ '-	 	 	D4610-7	COVER
	-	 ' 	 	1		 	D4611-1	BUSHING
) () I		1	+	 - '	 	 	D4622-1	PLACARD
) 	<u> </u>	1	-	 		 	D4622-3	PLACARD
)1 }		 '		 		 	D4022-3	1 BAOARD
- 11		 	1	1	— —		AN3-10A	BOLT
- 11		 	 	 	1	1	AN3-13A	BOLT
<u> </u>	 	+	1	1	† '	 	AN315-4R	NUT
$\frac{n}{n}$	 	 	 '		1 1	1 1	AN3-5A	BOLT
$\frac{\eta}{\eta}$	 	+	2	2	 	'	AN3-6A	BOLT
$\frac{1}{t}$	 	 	1	1	 	†	AN4-10A	BOLT
\	 	 	2	+'-	-	+	AN4-11A	BOLT
	 	+	 - -	2	+	 	AN4-12A	BOLT
	ļ		1	1-	+	-	AN4-13A	BOLT

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Revision: C

Date: 12.04.12

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Sty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description		
				1			MS20002-4	WASHER		
				1			MS20004-24	BOLT		
			3	3	2	2	MS21042L3	NUT (OR MS21042-3)		
			5	5			MS21042L4	NUT (OR MS21042-4)		
سد4.سم	4	4		-	,		MS21919DG5	CLAMP		
			1				MS24694-S102	SCREW		
				1			MS24694-S104	SCREW		
	2						MS35489-10	GROMMET		
		1			Ĭ		MS35489-149	GROMMET		
			1	1			MS9519-10	BOLT		
			4	4	2	2	NAS1149D0332J	WASHER (OR AN960JD10L)		
			5	5	2	2	NAS1149D0363J	WASHER (OR AN960JD10)		
			3	2			NAS1149D0416J	WASHER (OR AN960JD416L)		
			14	13			NAS1149D0463J	WASHER (OR AN960JD416)		
					3	3	NAS509-3	NUT		

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